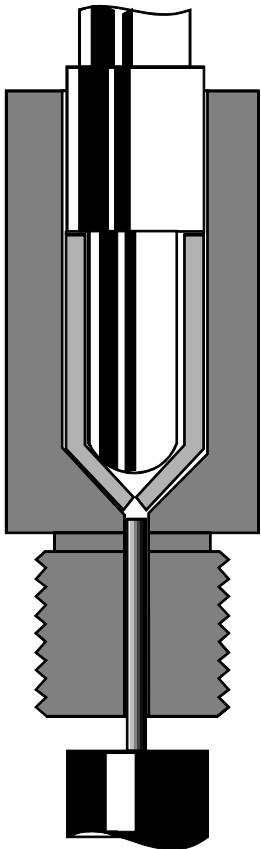




End Rounding Die
for
CTJM-1
Jacket Maker Kit

Type: -M -S -H

Tubing Diameter: _____



The End Rounding or Jacket Maker die is the **FIRST STEP** in turning a piece of cut tubing into a bullet jacket. Its purpose is to round over the end of the tube. To do this, you must use a punch that fits the ID of the tube snugly, and is about 1/2 caliber shorter than the tubing. That is, if you are using 3/8-inch tubing, then the tube should be cut about 3/16 inch longer than the punch (from shoulder to tip).



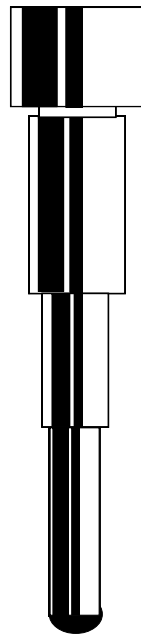
End Rounding Punch
for
CTJM-1
Jacket Maker Kit

Type: -M -S -H

Tubing Diameter: _____

Tubing Wall: _____

Tubing Length: _____



This punch is used in the End Rounding Die (Jacket Maker or J) to roll over the end of the tubing. The length of the punch tip should be about half the tubing diameter shorter than the proper tube length. That is, for 1/2-inch tubing, the tube should be about .25 inches longer than the punch tip.

For 3/8 tubing, the tube should be cut about 3/16 inch longer than the punch tip. For 5/16, cut the tubing about 5/32 longer. For 1/4, cut the tubing about 1/8 inch longer. Somewhat more does not hurt, but less prevents the end from closing because there is not enough length to close over the end of the punch. Too much causes the tubing to buckle rather than fold neatly.



End Flattening Punch
for
CTJM-1
Jacket Maker Kit

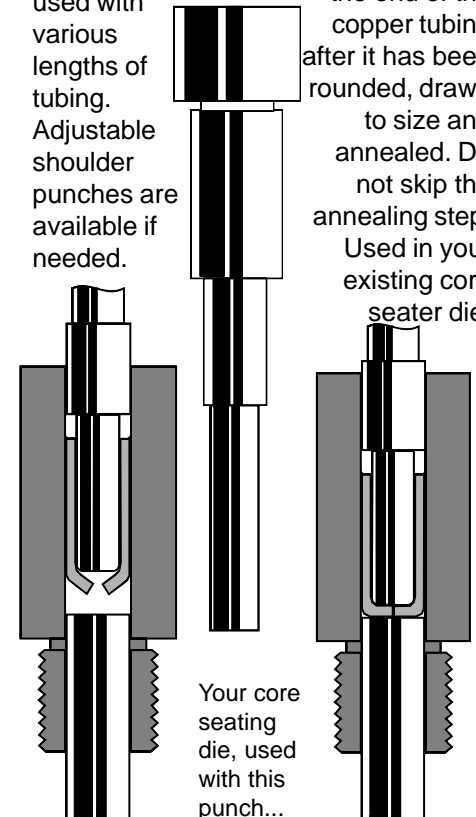
Type: -M -S -H

Caliber: _____

Wall thickness: _____

May be used with various lengths of tubing. Adjustable shoulder punches are available if needed.

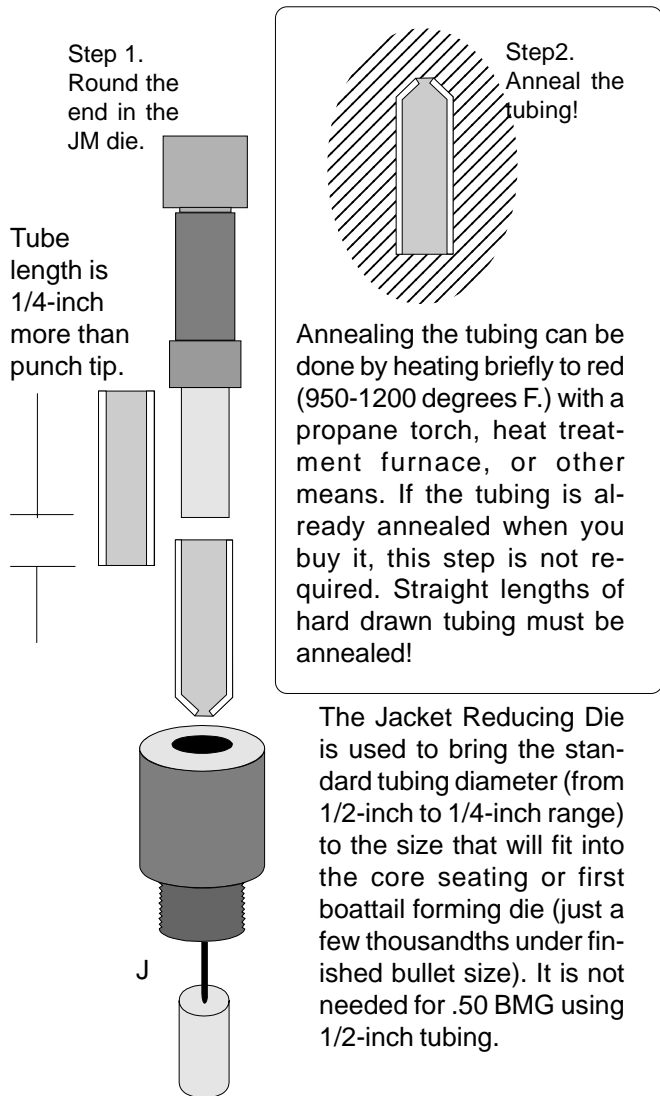
Used to flatten the end of the copper tubing after it has been rounded, drawn to size and annealed. Do not skip the annealing step. Used in your existing core seater die.



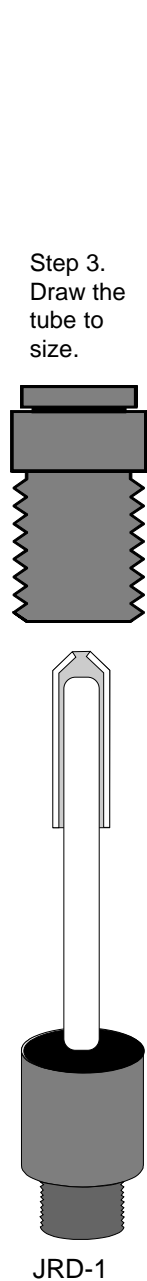
Your core seating die, used with this punch...

How to make a copper tubing bullet...

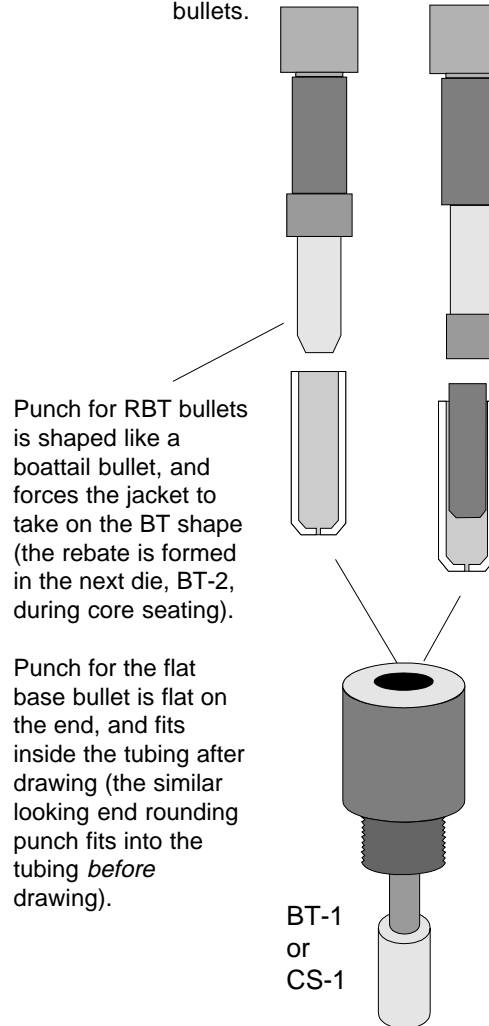
Tools required: CTJM-1 tubing jacket maker, plus a bullet swaging die set (FJFB-3, RBTO-4)



Jacket-maker die is also called the "end rounding" die, because it rounds the end of the tubing, providing that the tubing is at least 1/4-inch longer than the punch tip.

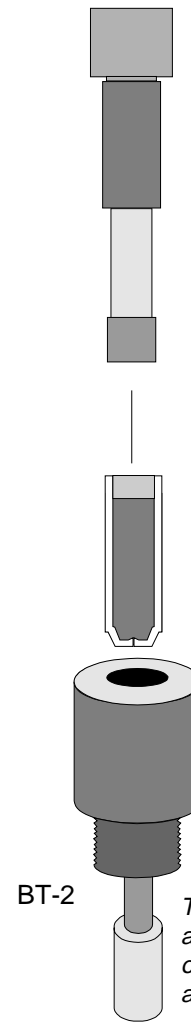


Step 4. Form BT-shape in BT-1 die for RBT bullets, or flatten the end in CS-1 die for flat base bullets.



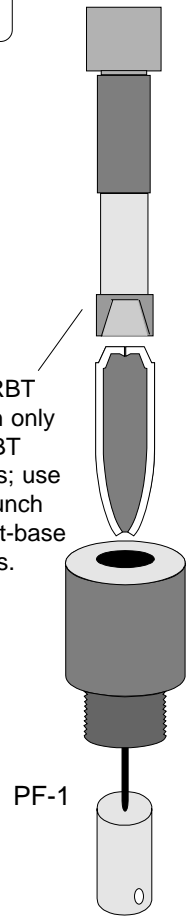
Step 5. Seat Core in CS-2 for flat base bullets.

Alternate Step 5. Seat Core in BT-2 die for RBT bullets.



Use RBT punch only for RBT bullets; use flat punch for flat-base bullets.

Step 6. Form the ogive.



Type -H dies and punches are illustrated. The same operation holds for type -M and -S sets.

Depending on whether you use a flat base or rebated boattail (RBT) design, you will use an "end flattening" punch to finish closing the end of the tube and /or to shape the boattail angle. The lead core is then inserted and swaged with a shorter core seating punch, either in the same core seat die (flat base) or in the BT-2 forming die (RBT base).